

WHAT IS CLAIMED IS:

1. In the manufacture of a web-shaped packaging laminate (22), comprising a core layer (24) of paper or paperboard, a method comprising the steps of coating (38) a first side of a material web (40) of paper or paperboard with an outer layer (26) of thermoplastic material, and thereafter, with the aid of laser burning (46, 48) forming, on the thus thermoplastic coated first side of the packaging laminate (22), a perforation line (32) through said thermoplastic layer (26) and said core layer (24), **characterised by** the step, after said coating (38) with the thermoplastic material, but before the formation of the perforation, of compressing (44, 10) the packaging laminate (22) on said first side, for the formation of a compression line (30) in which said core layer (24) is compressed, whereafter said perforation line (32) is formed in said compression line (30).
2. The method as claimed in Claim 1, **characterised in that** the compression line (30) and the perforation line (32) are formed in relation to one another such that a build-up of thermoplastic residual material (34) around the perforation line (32), after the laser burning (48, 46), will substantially be located entirely below the level of the surrounding surface of the packaging laminate (22), the core layer (24) preferably being compressed by at most 70%, preferably at most 60% but at least 20%, preferably at least 30% of its original thickness in said compression line (30).
3. The method as claimed in Claim 1 or 2, **characterised in that** the compression (30) is considerably wider than the perforation line (32), preferably at least 1.5 times, as wide, and even more preferably at least twice as wide, but at most ten times as wide, preferably at most five times as wide.
4. The method as claimed in any of the preceding Claims, **characterised in that** said web-shaped packaging laminate (22) is further processed after the forming of the perforation line (32), on rollers (52) and/or by rolling up on a reel (54).
5. A plant in the manufacture of a web-shaped packaging laminate (22) comprising a core layer (24) of paper or paperboard, the plant comprising a coating station (38) for forming a coating layer (26) of a thermoplastic material on a first side of said core layer, followed by a perforation station (46) including a laser burner (48), the perforation station being disposed to

form a laser-burned perforation line (32) on the first side of the packaging laminate (22) through said thermoplastic layer (26) and said core layer (24), characterised by a compression station (44) between said coating station (38) and said perforation station (46), including a compression tool (10) disposed to form a compression line (30) on said first side
5 of the packaging laminate (22), and that said perforation station (46) is disposed to form said perforation line (32) in said compression line (30).

6. The plant as claimed in Claim 5 characterised in that said compression tool (10) includes a roller (12) which displays a projecting compression portion (16) around its
10 circumference, said projecting compression portion being preferably 1-3 mm and even more preferably 1.5-2.5 mm wide and preferably 0.2-2 mm and even more preferably 0.2-1 mm high above the surrounding surface (14) of the roller, as well as a counter roller (18) which preferably displays a smooth circumferential surface, a gap (20) between said roller (12) and said counter roller (18) being adjustable.

7. The plant as claimed in Claim 5 or 6 characterised in that it includes additional, subsequent stations for further processing or handling of the packaging laminate, including rollers (52) and/or stations for rolling up the packaging laminate on a reel (54).

8. A packaging laminate comprising a core layer (24) of paper or paperboard as well as a thermoplastic coating layer (26) on a first side thereof, displaying a laser-burned perforation line (32) through the core layer (24) and the thermoplastic layer (26), characterised in that said perforation line (32) is disposed in a compression line (30) on the first side of the packaging laminate (22), in which compression line said core layer is compressed.

9. The packaging laminate as claimed in Claim 8, characterised in that the compression line (30) and the perforation line (32) are formed in relation to one another so that a build-up of thermoplastic residual material (34) around the perforation line is substantially located entirely below the level of the surrounding surface of the packaging laminate (22), the core
30 layer (24) preferably being compressed in said compression line by at most 70%, preferably at most 60% but at least 20%, preferably at least 30% in relation to its thickness surrounding the compression line (30).

10. The packaging laminate as claimed in Claim 8 or 9, **characterised in that** the compression line (30) is considerably wider than the perforation line (32), preferably at least 1.5 times as wide, and even more preferably at least twice as wide, but at most ten times as wide, preferably at most five times as wide.

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11. The packaging laminate as claimed in any of Claims 8 to 10, **characterised in that** said thermoplastic coating layer (26) displays a surface weight or grammage of 20-50 g/m², preferably 20-40 g/m², and that it preferably includes a thermoplastic material selected from the group essentially comprising polyethylene and polypropylene.